

Date Wednesday, 15/08/2007 4:00:36 PM  
User Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Jot Number : 33943  
Estimate Number : 10347  
P.C. Number :  
This Issue : 15/08/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : 11 Type : MACHINED PARTS  
Previous Run : 33453  
Written By : *[Signature]*  
Checked & Approved By :  
Comment : Est C 00.06.22 Removed P/O for powder coat EC  
Est D 06.03.30 Added level 8 EC

Drawing Name : HINGE BRACKET  
Part Number : D28572  
Drawing Number : D2857 REV B  
Project Number : N/A  
Drawing Revision : B  
Material :  
Due Date : 15/09/2007 Qty: *40* Um: Each

## Additional Product

Jot Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X01250 6061-T6 Bar 2.0" x 1.25"



Comment: Qty.: 0.4594 f(s)/Unit Total: 13.7813 f(s)  
Material: 2.00" X 1.25"  
6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)  
(M6061T6B200001250)  
Batch *M105838 13.7813*

*S.F. 07/10/22* (40)

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
Cut blanks 5.2"

*S.F. 07/10/22* (40)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
Machine per folio D2857-2

*J.L. 07/10/24* 39

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L. 07/10/24* 39

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2857-2 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>33943</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/10/24</u>	<u>3</u>	<u>1 part scrapped, operator put part on wrong side on 4th axis RC Humana error.</u>	<u>[Signature]</u>	<u>Scrap and destroy and replace.</u>	<u>J.L 07/10/24</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:00:36 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 33943

Part Number: D28572

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JF.

07/10/24

(39)

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

JF

07.10.29

(39)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

FD

07/10/29

(39)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

07-10-29

(39)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M 105068 - M 105914

BR

07-10-30

(39)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/10/30

(39)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST50

(39)

07/10/31

AS

LC

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.31

HA

Job Completion



W 07.10.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		<del>Insert change</del> Oc 3/6 Oc					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

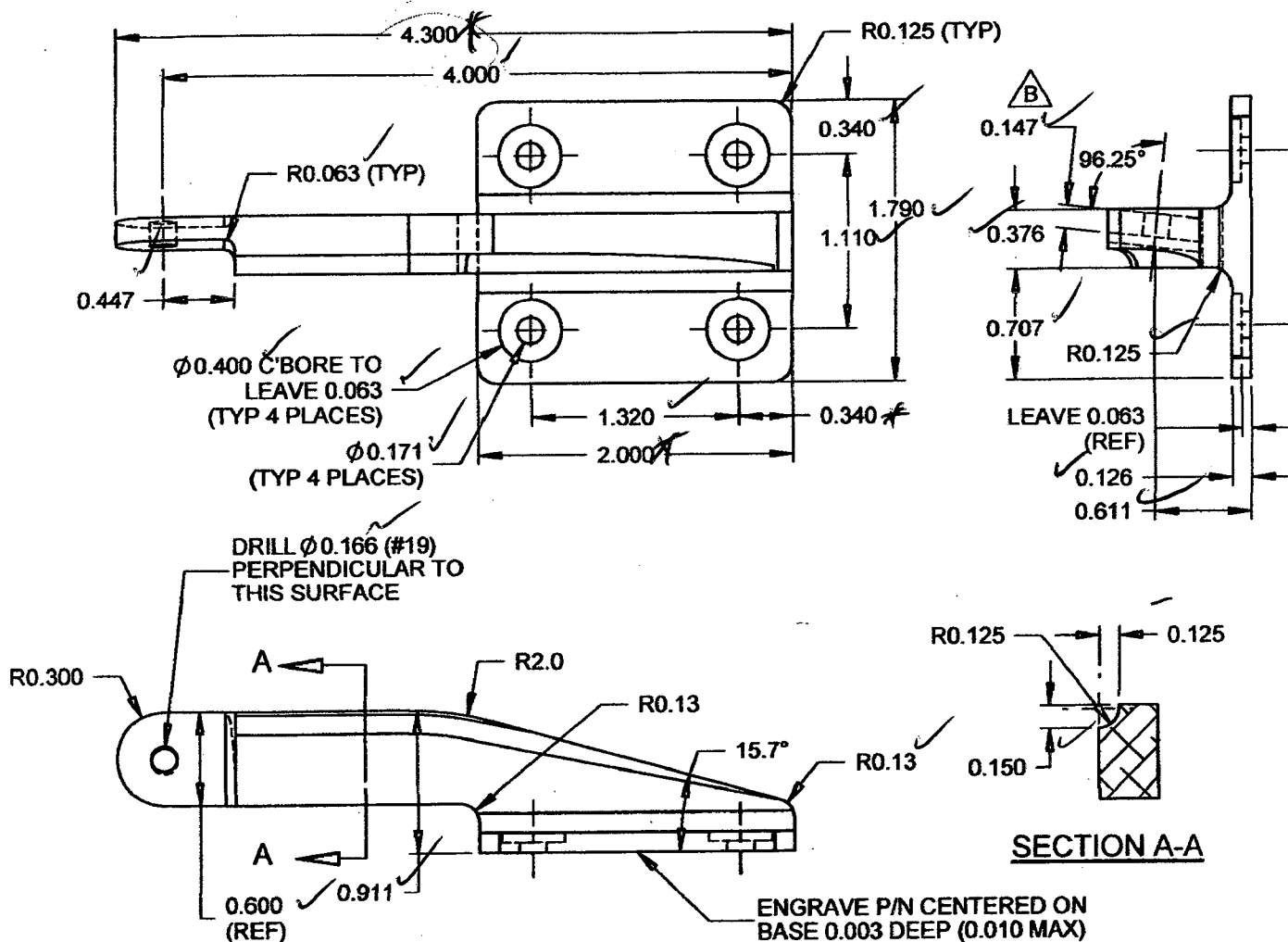
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET		SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

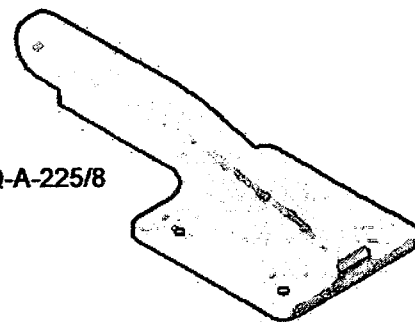
RELEASED  
06.10.13



**D2857-1 HINGE BRACKET**  
**D2857-2 OPPOSITE**

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	33943
<b>Description: Hinge Bracket</b>		<b>Part Number:</b>	D2857-2
<b>Inspection Dwg: D2857      Rev: B</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.310	✓			
4.000	+/-0.010	4.009	✓			
0.340	+/-0.010	.342	✓			
1.110	+/-0.005	1.110	✓			
1.790	+/-0.010	1.791	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.001	✓			
0.340	+/-0.010	.339	✓			
0.447	+/-0.010	.446	✓			
Ø0.171	+0.005/-0.000	.173	✓			
0.147	+/-0.010	.144	✓			
0.376	+/-0.010	.376	✓			
0.126	+/-0.010	.127	✓			
0.063	+/-0.010	.065	✓			
Ø0.166	+0.005/-0.000	.167	✓			
0.911	+/-0.010	.907	✓			
0.600	+/-0.010	.610	✓			
0.125	+/-0.010	.122	✓			
0.150	+/-0.010	.146	✓			

<b>Measured by:</b>	JL	<b>Audited by:</b>	JNL	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/10/23	<b>Date:</b>	07/10/24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	